

Work Order ID 59490

Friday, June 04, 2010 2:49:55 PM



Page 1

Item ID: D4008-11

Accept



Setup Start



Revision ID:

Item Name: Hinge Half

Stop



Start Date: 6/4/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-6-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D4008	A

100



Small Fab

Memo

0.00

Small Fab

1- Cut Hinge as per Dwg keep 2nd half for D4008-15

2- Deburr

fp 10/06/16 ④

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*Stocked**(84)*

120



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

10-6-17 SL ④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59490

Friday, June 04, 2010 2:49:55 PM



Page 2

Item ID: D4008-11

Revision ID:

Item Name: Hinge Half

Start Date: 6/4/2010 Start Qty: 4.00

Required Date: 6/10/2010 Req'd Qty: 4.00

Accept



Setup

Start



Stop

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Memo

10/06/22 AD

MF

10-6-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 2:49:59 PM

Page 1

Work Order ID: 59490



Parent Item: D4008-11



Parent Item Name: Hinge Half

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP REV:A NEW ISSUE 10-04-06 JLM VERIFIED BY:EC
10.05.03 as per ECN10-562 DD verified by:EC

IPP Rev:B

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200			No			100	f	1.7100	0.4	1.684211			

Piano Hinge

Location	Loc Qty	Loc Code
ST489A	1.71	
113368	1.71	

EF 10/06/10

M110267 (4X)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

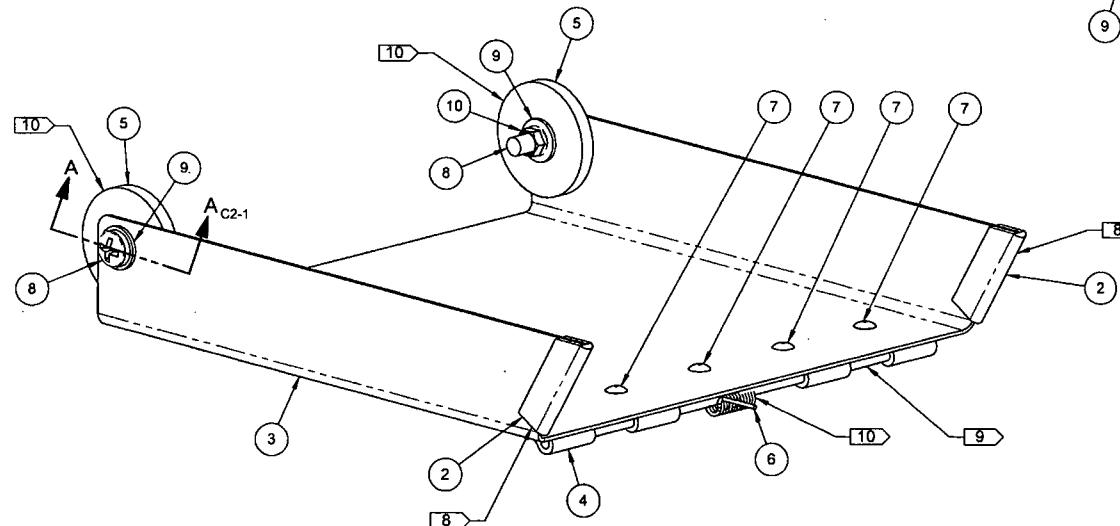
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

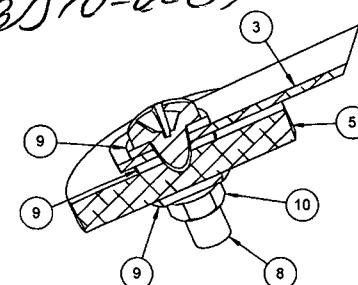
NO. 59490

3/10-6-07

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-041	AUX TANK FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
2	2	D3941-1	RUBBER CUSHION	
3	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
4	1	D4008-5	HINGE	
5	2	D4008-7	WASHER	
6	1	D4008-9	SPRING	
7	5	MS20470AD3-3	RIVET	
8	2	MS35206S245	SCREW	
9	6	NAS1149DN832J	WASHER	
10	2	MS21042L08	NUT	



SECTION A-A
SCALE: 2X B6-1
TYP



D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4008-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.15 lbs
- 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT
- 9) MASK HINGE PIN AREA BEFORE POWDER COAT
- 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT

A	NEW ISSUE	10.02.05
REV.	DESCRIPTION	BY DATE
DESIGN	10.02.05	DART AEROSPACE LTD
DRAWN	10.02.05	HAWKESBURY, ONTARIO, CANADA
CHECKED	10.02.05	DRAWING NO. REV. A
MFG. APPR.	10.02.05	D4008 SHEET 1 OF 10
APPROVED	10.02.05	TITLE SCALE
DE APPR.	10.02.05	SPLASH GUARD NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

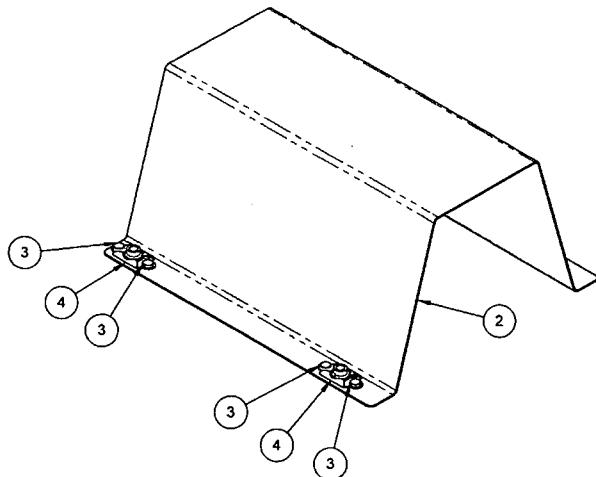
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. 043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-043	FUEL PUMP SPLASH GUARD ASSEMBLY	JCA-M47-2-29
2	1	D4008-3	FUEL PUMP SPLASH GUARD COVER	
3	8	MS20426AD3-3	RIVET	
4	4	MS21059L08	NUT PLATE	



D4008-043 FUEL PUMP SPLASH GUARD ASSEMBLY

wl6 5949d

RELEASED
2010-05-05
W

NOTES:
 1) MATERIAL:
 2) FINISH: POWDER COAT "GREY SANDEX" (4,3,5,6) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4008-043" AND B/N USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.46 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. A
APPROVED	<i>[Signature]</i>	D4008
DE APPR.	<i>[Signature]</i>	SCALE
DATE	10.02.05	NTS

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

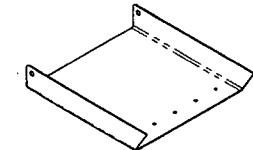
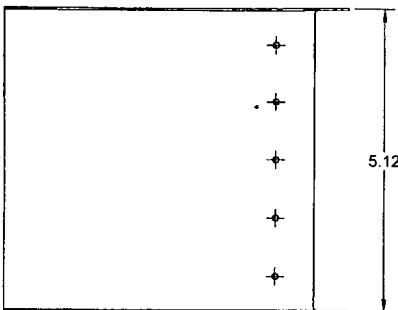
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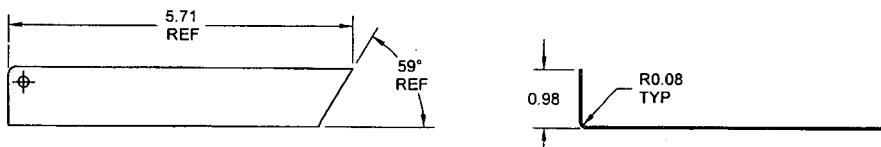
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-1	REF JCA-M47-2-26

D



C



WB59490

D4008-1 FUEL FILLER SPLASH GUARD CHANNEL

NOTES:

- 1) MATERIAL: MADE FROM D4008-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

8

7

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4

3

2

1

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
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CHECKED	<i>[Signature]</i>	REV. A
MFG. APPR.	<i>[Signature]</i>	D4008
APPROVED	<i>[Signature]</i>	SHEET 3 OF 10
DE APPR.	<i>[Signature]</i>	TITLE
DATE	10.02.05	SCALE
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RELEASED
2010-05-15
[Handwritten signature]

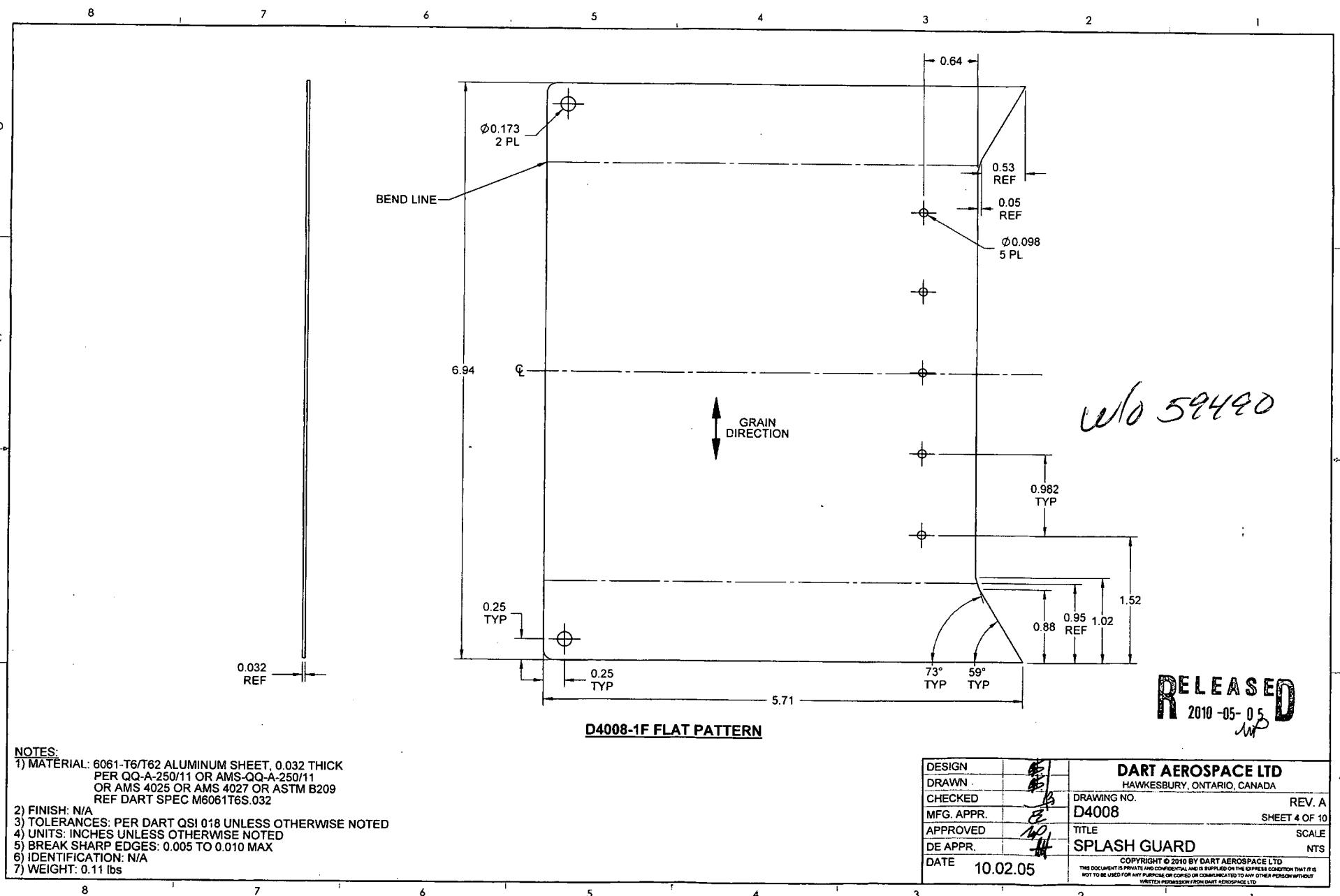
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>BB</i>	DART AEROSPACE LTD
DRAWN	<i>BB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BB</i>	REV. A
MFG. APPR.	<i>BB</i>	DRAWING NO.
APPROVED	<i>BB</i>	D4008
DE APPR.	<i>BB</i>	SHEET 4 OF 10
DATE	10.02.05	TITLE
		SPLASH GUARD
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		NTS

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

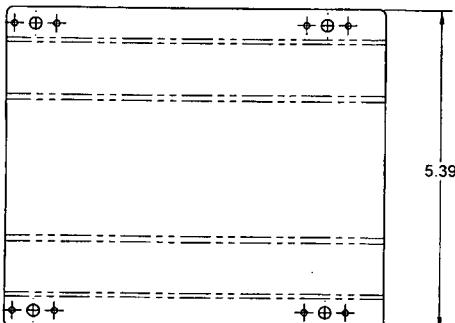
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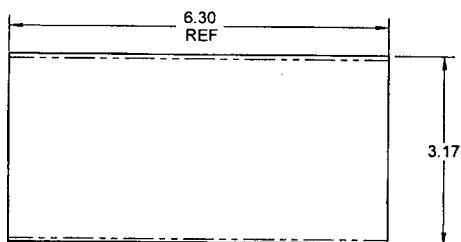
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-3	REF JCA-M47-2-29

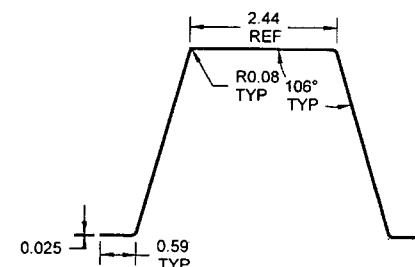
D



C



B



A

NOTES:

- 1) MATERIAL: MADE FROM D4008-3F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs

8

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5

4

3

2

1

D4008-3 FUEL PUMP SPLASH GUARD COVER

RELEASED
R 2010-05-05
NP

DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	
MFG. APPR.	<i>AB</i>	REV. A
APPROVED	<i>AB</i>	D4008 SHEET 5 OF 10
DE APPR.	<i>AB</i>	TITLE SPLASH GUARD
DATE	10.02.05	SCALE NTS

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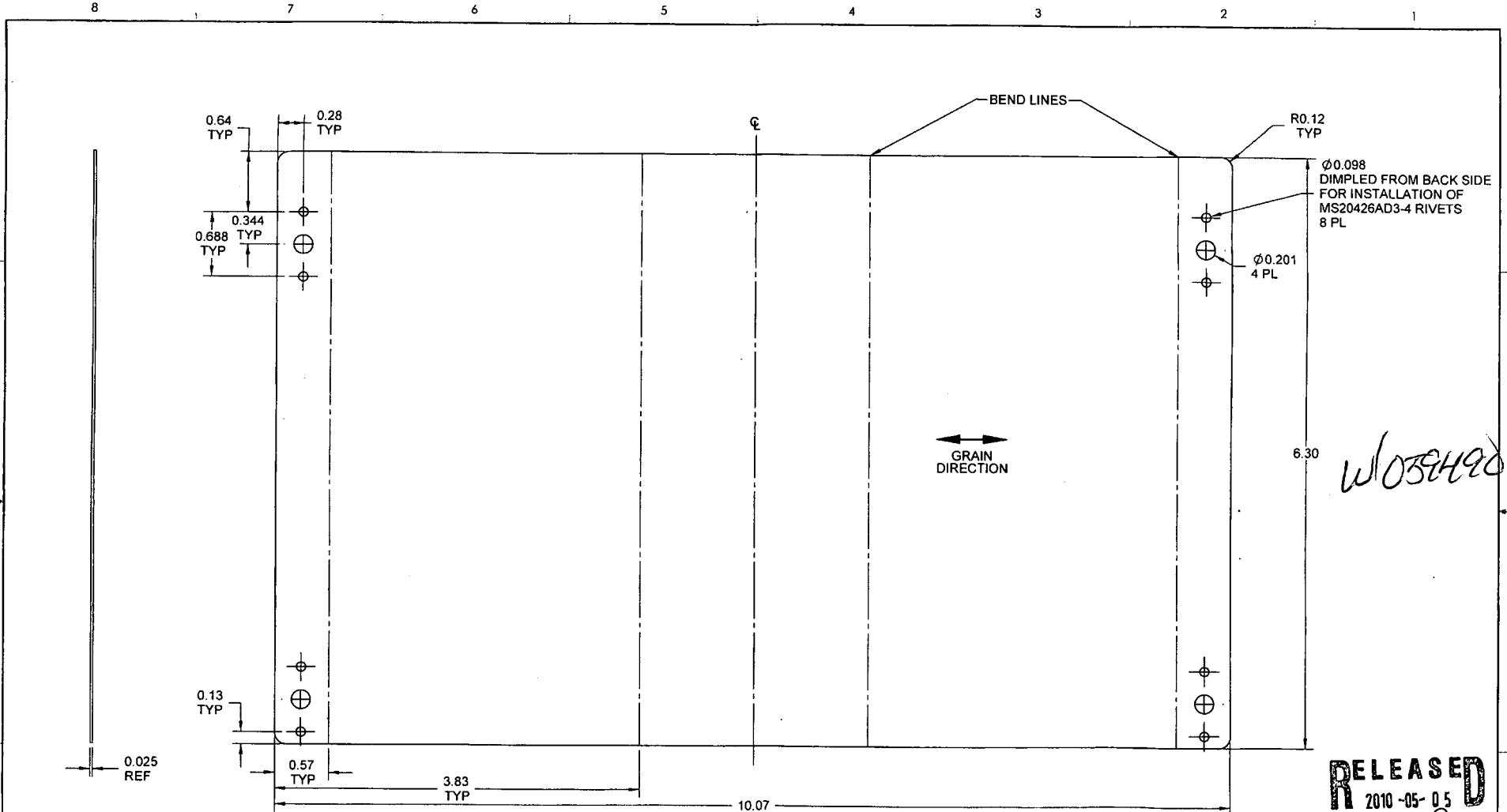
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.025 THICK PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASTME SA240 REF DART SPEC M303S24GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs

D4008-3F FLAT PATTERN

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
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MFG. APPR.		
APPROVED		
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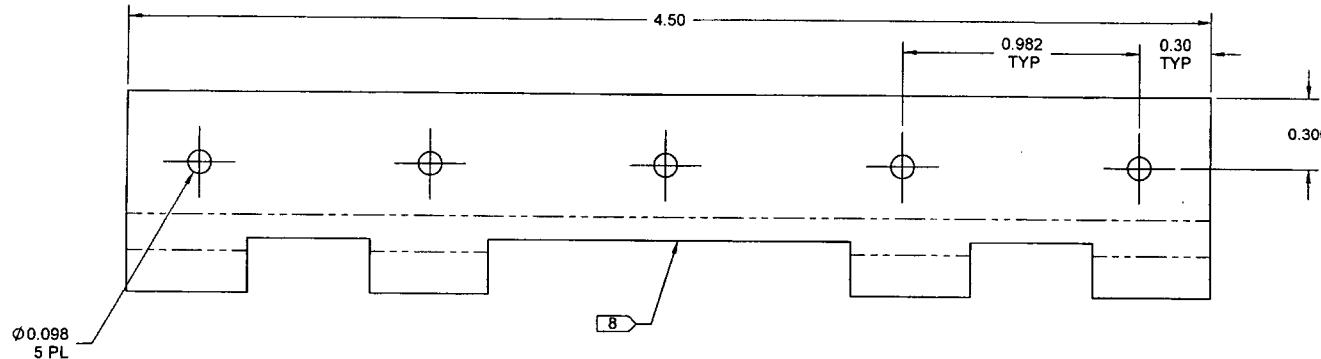
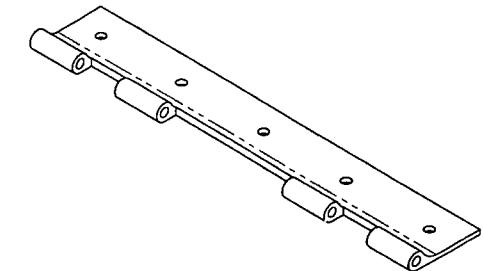
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

DART AEROSPACE PART NUMBER D4008-5	JOHN CAMERON AVIATION PART NUMBER REF JCA-M47-2-26
--	--



D4008-5 HINGE HALF

W/0 59490

RELEASED
2010-05-05
WP

A NOTES:

- 1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs
- 8) REMOVE CENTER LUG FROM THIS AREA, FLUSH WITH THIS EDGE

DESIGN	<i>EE</i>	DART AEROSPACE LTD
DRAWN	<i>EE</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BB</i>	
MFG. APPR.	<i>EE</i>	
APPROVED	<i>WP</i>	REV. A
DE APPR.	<i>WP</i>	SHEET 7 OF 10
DATE	10.02.05	TITLE
		SCALE
		NTS
		SPASH GUARD
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

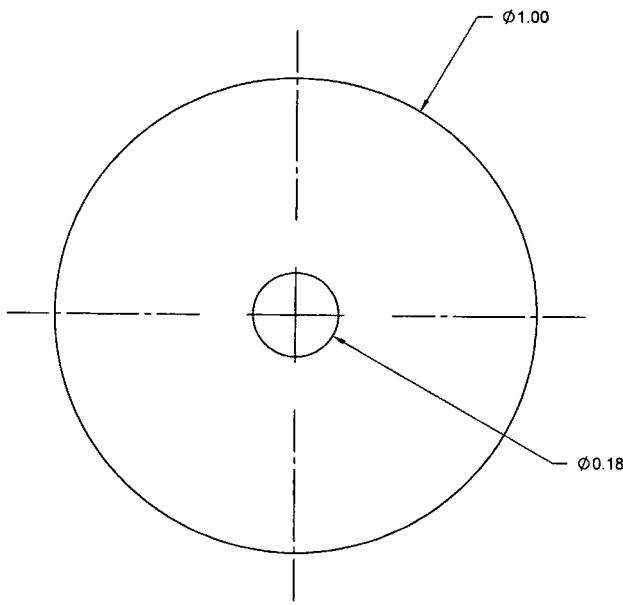
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

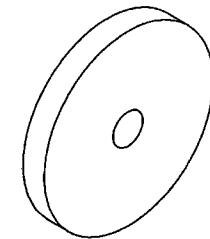
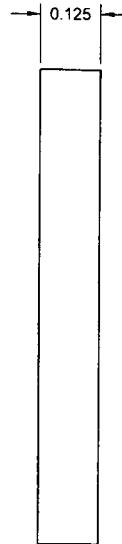
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-7	REF JCA-M47-2-26



D4008-7 WASHER



W10 5G490

RELEASED
2010-05-05
MW

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, Ø1.00 ROUND BAR, BLACK
REF DART SPEC M-DELRIN-R1.000
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN	<i>AE</i>	DART AEROSPACE LTD
DRAWN	<i>AE</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BS</i>	DRAWING NO.
MFG. APPR.	<i>AE</i>	REV. A
APPROVED	<i>AE</i>	D4008
DE APPR.	<i>AE</i>	SHEET 8 OF 10
DATE	10.02.05	TITLE
		SCALE
		NTS
		SPLASH GUARD

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

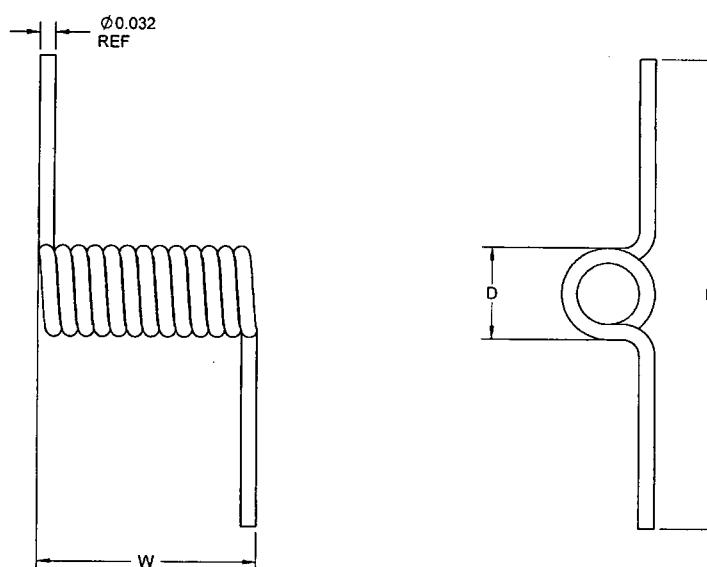
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DART AEROSPACE PART NUMBER D4008-9	JOHN CAMERON AVIATION PART NUMBER REF JCA-M47-2-26
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SPECIFICATION CONTROL DRAWING



w/0 59498

DART P/N	SUPPLIER	SUPPLIER P/N	WIDTH "W"	HEIGHT "H"	DIAMETER "D"	MATERIAL
D4008-9	VICTORY SPRING	N/A	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE
D4008-9	BELL HELICOPTER	206-031-140-001	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE

D4008-X SPRING

NOTES:

- 1) MATERIAL: T301 OR 304 STAINLESS STEEL SPRING WIRE Ø0.032 PER ASTM A313
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	DRAWING NO. D4008 REV. A
APPROVED	<i>[Signature]</i>	SHEET 9 OF 10
DE APPR.	<i>[Signature]</i>	TITLE SPLASH GUARD
DATE	10.02.05	SCALE NTS

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RELEASED
2010-05-05
MP

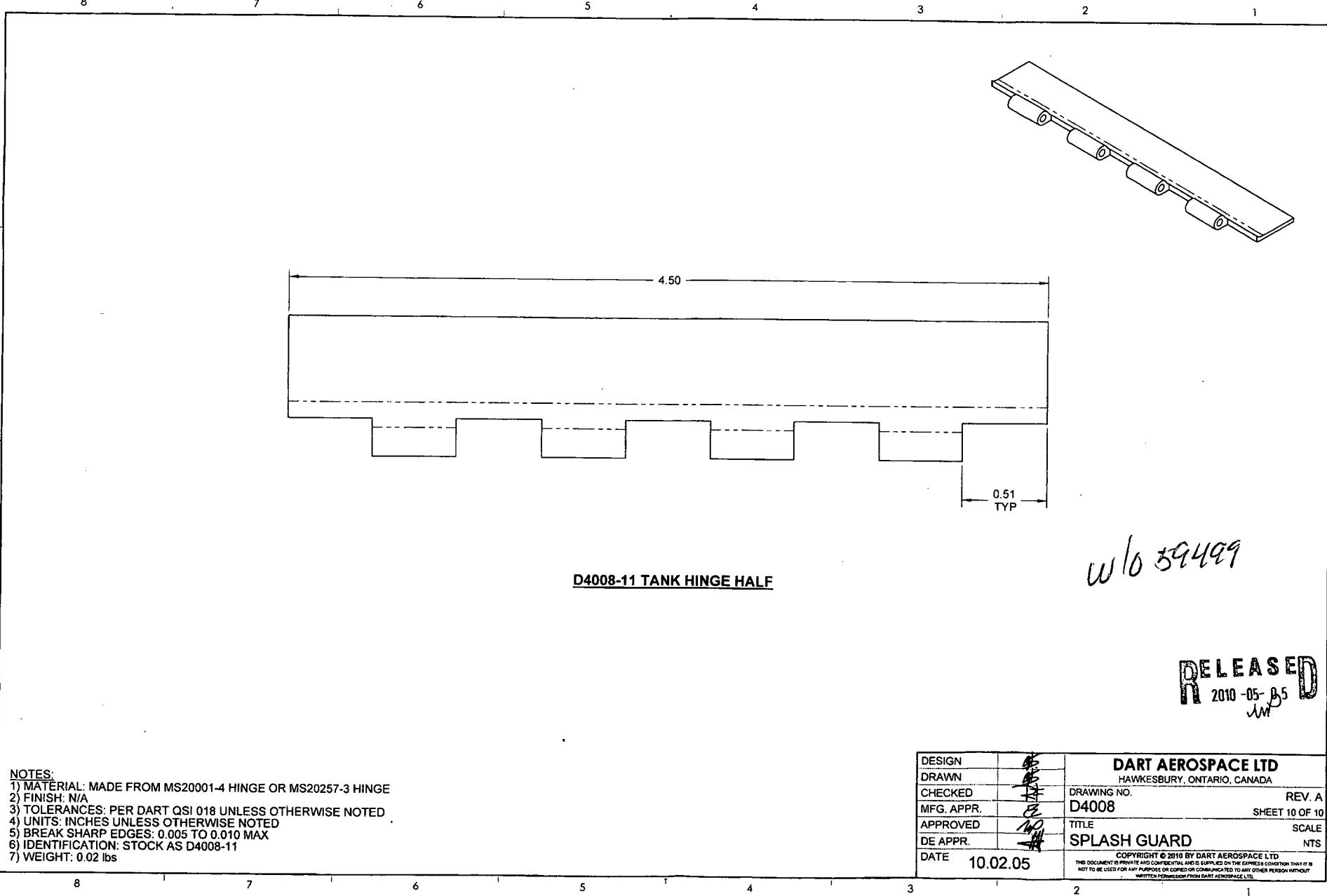
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries